

Shp Thurs 13/10

Work Order ID 74858

October-12-11 11:59:07 AM

\*74858\*

~~PRELIMINARY ISSUE~~

Item ID: D4404-7  
Revision ID: PRELIM  
Item Name: Cushion, Upper Side

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Start Date: 10/12/11 Start Qty: 1.00 \*1\*  
Required Date: 10/12/11 Req'd Qty: 1.00 \*1\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *W*  
QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4404	<i>PB3 B 11.10.12</i>								
100		0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D4404 Prog. rev: <i>PB3</i> Dwg rev: <i>PB3</i>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

B11-10-12

(1)

B11-10-12

*m 11.10.13 (1)*  
*AS per PB3 Dwg*

# Work Order ID 74858

October-12-11 11:59:07 AM

**\*74858\***

Page 2

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Revision ID: PRELIM  
Item Name: Cushion, Upper Side

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Start Date: 10/12/11 Start Qty: 1.00 **\*1\***  
Required Date: 10/12/11 Req'd Qty: 1.00 **\*1\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11/12/12 AUTH J

RELEASED 11/12/12 DATE 11.10.12

OKAY TO SHIP TO CUSTOMER

\* COPY OF DSI 9577 WILL FOLLOW EARLY NEXT WEEK  
WITH RELEASE OF PAPERWORK.

# Picklist Print

October-12-11 11:59:07 AM

Page 1

Work Order ID: 74858

Parent Item: D4404-7

Parent Item Name: Cushion, Upper Side

Start Date: 10/12/11

Required Date: 10/12/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 11.10.12 new Issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	481.8500	2.964	3.12			
NEOPRENE SHEET 0.063													

## Location

## Loc Qty

## Loc Code

MAT052

481.85

117295

55.68

118026

127.87

118663

4.3

119130

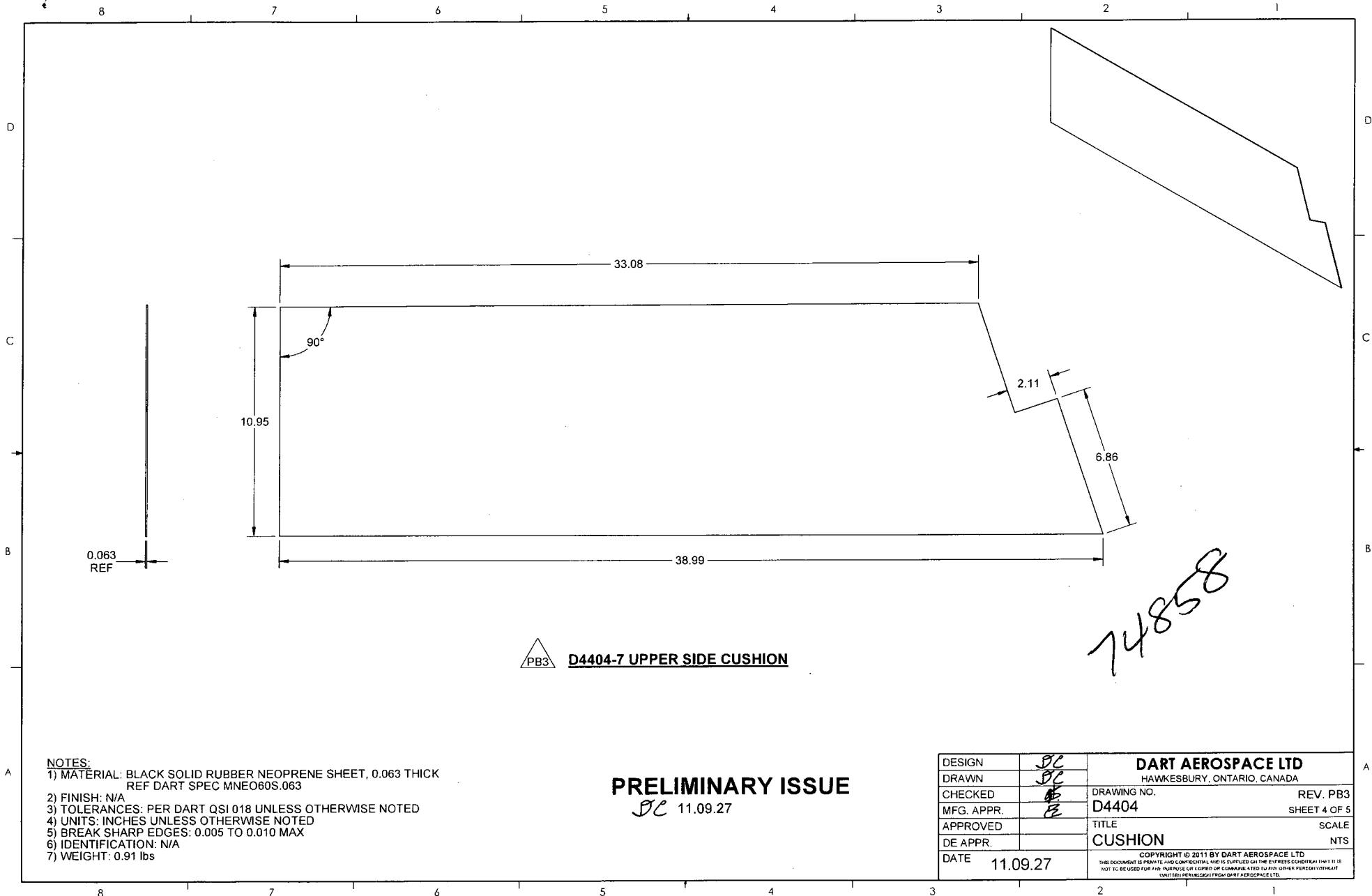
294

HB 11-10-12

⑪

119130





**D4404-7 UPPER SIDE CUSHION**

**NOTES:**

- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK  
REF DART SPEC MNE060S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs

**PRELIMINARY ISSUE**

*DC* 11.09.27

DESIGN	<i>DC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>		
CHECKED	<i>DC</i>	DRAWING NO. <b>D4404</b>	REV. PB3 SHEET 4 OF 5
MFG. APPR.	<i>DC</i>	TITLE <b>CUSHION</b>	SCALE NTS
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DATE	11.09.27		

## Marc Bellavance

---

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** October 3, 2011 10:43 AM  
**To:** 'Daniel Campbell'  
**Cc:** 'Marc Bellavance'; 'Harvey Siemens'; Mike Petsche  
**Subject:** RE: D350-794 Aux Tank Cushion

**Follow Up Flag:** Follow up  
**Flag Status:** Completed

Dan,

Marc and I discussed this this morning and we believe it is best to create a D4404-7 cushion specifically for the back side of the old tanks. We will then create a DSI kit that allows customers with existing tanks to add the cushions to the bottom, back, and fwd faces.

If you can update the D4404 dwg, then Marc has agreed to create the necessary DSI for this.

David

---

**From:** Daniel Campbell [<mailto:dcampbell@dartaero.com>]  
**Sent:** September-28-11 8:48 AM  
**To:** David Shepherd  
**Cc:** Marc Bellavance; Harvey Siemens  
**Subject:** D350-794 Aux Tank Cushion

Hi David,

There's a customer looking for a foam cushion to go on the inboard vertical side of the tank.

I have designed a cushion for the newer/updated tank, however, the customer has the older version of the tank.

Marc, Harvey, and I have been in discussion about this and Marc has drawn up the attached diagram, showing the customer how he can cut and trim the one piece cushion to fit the tank.

I've also included D4404-PB1 drawing which shows the -3 cushion before it is cut/trimmed.

How should we go about getting this off to the customer?

Should I/we:

1. Include this in the IIN/ICA?
2. Create a DSI for it?
3. Just manufacture it and send it along with Marc's diagram to the customer?
4. Other option?

Marc – maybe you can find out how quickly the customer is looking for a fix?

Thanks,

Daniel Campbell  
Mechanical Engineer  
DART Aerospace Ltd.

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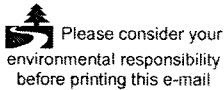
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## Marc Bellavance

---

**From:** Marc Bellavance <mbellavance@dartaero.com>  
**Sent:** September 28, 2011 9:41 AM  
**To:** 'Harvey Siemens'; 'Daniel Campbell'  
**Subject:** RE: D350-794

No, it will unfortunately make it even shorter.



**Marc Bellavance**  
**Technical/Shop Support**  
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**From:** Harvey Siemens [mailto:hsiemens@dartaero.com]  
**Sent:** September 28, 2011 9:30 AM  
**To:** 'Marc Bellavance'; 'Daniel Campbell'  
**Subject:** RE: D350-794

What about if you fold the cushion into the bend? I'll bet you can make it fit then? ☺ ☺

Regards,

*Harvey Siemens*

Mechanical Designer  
DART Aerospace Ltd.

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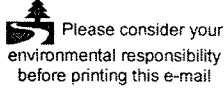
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**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** September-28-11 7:18 AM  
**To:** 'Harvey Siemens'; 'Daniel Campbell'  
**Subject:** RE: D350-794

It makes sense, and I'm really in favour for having only one P/N for that side cushion, but based on how D4404-3 fits on D4055-041, see attached, I think we need another P/N...





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---

**From:** Harvey Siemens [mailto:hsiemens@dartaero.com]  
**Sent:** September 28, 2011 9:00 AM  
**To:** 'Marc Bellavance'; 'Daniel Campbell'  
**Subject:** RE: D350-794

Marc

I think as long as we add a note to "trim to fit" one side would be ok. If you really think that we need to have 2 different ones we could do that too.

Regards,

*Harvey Siemens*

Mechanical Designer  
DART Aerospace Ltd.

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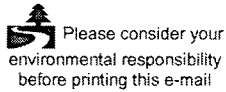
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**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** September-28-11 6:24 AM  
**To:** 'Daniel Campbell'  
**Cc:** 'Harvey Siemens'  
**Subject:** RE: D350-794

Thanks for this Dan/Harvey.

My only concern is that this customer has the old tank and other customers might run into the same problem. Would it be too much trouble to add a D4404-7 Side Cushion that would fit the current tank? D4404-5 would be OK for both tank design.



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**From:** Daniel Campbell [mailto:dcampbell@dartaero.com]  
**Sent:** September 27, 2011 4:44 PM  
**To:** 'Marc Bellavance'  
**Cc:** Harvey Siemens  
**Subject:** RE: D350-794

Hi Marc,

I talked to Harvey and he thought it would be okay to go ahead with a prelim dwg and manufacture parts from that. (Perhaps it needs a positive recall? – I'm not sure of the exact terms).

Anyway, I have created D4404-PB1 which in the Prelim folder, along with the dxfs. Harvey has checked this dwg.

You can ahead and have these parts cut and test fit on one the tanks you've got there. The D4404-3/-5 will probably be a little bit shorter since the updated tank will be slightly shorter to accommodate the FAA required sumps.

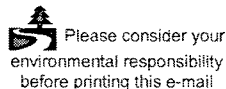
If the fit of these parts is ok, then they probably can go out to the customer.

Cheers,  
Dan

---

**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** September-27-11 11:44 AM  
**To:** 'Daniel Campbell'  
**Subject:** RE: D350-794

Yes, only a released drawing for the foam cushions. Unless David is OK if we supply the part under positive recall. In that case, a prelim issued drawing would work. Perhaps we can start manufacturing with a prelim issued drawing? This is mainly to satisfy this one customer.



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**From:** Daniel Campbell [mailto:dcampbell@dartaero.com]  
**Sent:** September 27, 2011 1:15 PM  
**To:** 'Marc Bellavance'  
**Subject:** RE: D350-794

Hi Marc,

I can have the drawing done for the foam cushions fairly quickly – David doesn't get back to the office until Friday. So, I think the earliest it would be approved would be then.

However, I'm doing a whole bunch of updates & changes for the aux tank – some driven by CARs and PARs and others by the requirements to get it certified for the FAA. I have about 10 drawings to update/re-do and the IIN & ICA will probably need updating, too. Then, it needs to get approved by the FAA.

Are you looking for just a released drawing for the foam cushions?

Thanks,  
Dan

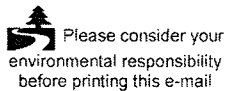
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**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** September-27-11 7:06 AM  
**To:** 'Daniel Campbell'  
**Subject:** RE: D350-794

No problem Dan.

It would make sense to cover the entire area of the inboard face, aesthetically better than to have a few strips installed here and there. When do you think you can have the drawing ready for approval? I'm asking because I just received an email (attached) from a customer in need of that.

Thanks,



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-----Original Message-----

**From:** Daniel Campbell [mailto:dcampbell@dartaero.com]  
**Sent:** September 26, 2011 4:55 PM  
**To:** 'Marc Bellavance'  
**Subject:** RE: D350-794

Hi Marc,

Thank you very much. This is exactly what I was looking for.

I had thought that the inboard face cushioning should be the entire area of the inboard face.

Should it have a different/smaller shape?

Thanks,  
Dan

-----Original Message-----

From: Marc Bellavance [mailto:mbellavance@dartaero.com]

Sent: September-26-11 2:56 PM

To: Daniel Campbell

Subject: D350-794

Here you go Dan. Let me know if you need details about the inboard face cushioning.

Marc

